

Date: Wednesday, 6/6/2007 1:43:15 PM  
User: Kim Johnston

Process Sheet

1 x PIONEER 26

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DART 13-MAN 3-POINT SHOULDER HARNESS KIT
Job Number : 32760	
Estimate Number : 12865	
P.O. Number : N/A	Part Number : D412702041B
This Issue : 6/6/2007 S.O. No. : N/A	Drawing Number : D412702041B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : D
Previous Run : 32759	Material : N/A
Written By : <u>JS 07.06.07</u>	Due Date : 6/30/2007 Qty: 2 Um: Each
Checked & Approved By : <u>JS 07.06.07</u>	
Comment : est rev A 07.05.10 new issue EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-702-041B CHG001 002

JS 07.06.08

2.0 D412702059 GROMMET KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GROMMET KIT

batch: B32327 (x2)

JS 07/11/15

3.0 D412702101B HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32790 (x4)

JS 07/11/15

4.0 D412702103B HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32809 (x4)

JS 07/11/15

5.0 D412702105B HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32608 x2

JS 07/11/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 6/6/2007 1:43:15 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32760

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D412702107B

HARNESS ASSEMBLY



(P13)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
HARNESS ASSEMBLY  
batch: B33840 (x2)

AS 07/11/15

7.0

D412702109B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
HARNESS ASSEMBLY  
batch: B32811 (x2)

AS 07/11/15

8.0

D412702111B

HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
HARNESS ASSEMBLY  
batch: B32812 (x4)

AS 07/11/15

9.0

D412702113B

HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
HARNESS ASSEMBLY  
batch: B32813 (x4)

AS 07/11/15

10.0

D412702115B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
HARNESS ASSEMBLY  
batch: B32491

AS 07/11/15

11.0

D412702117B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
HARNESS ASSEMBLY  
batch: B32492 (x2)

AS 07/11/15

12.0

D35421

BRACKET






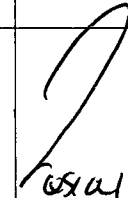
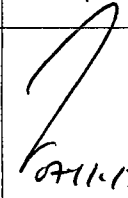
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BRACKET  
batch: B32606 (x2)

AS 07/11/15

Take out

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-702-041B PAR #: NA Fault Category: Prod Packaging NCR: Yes No DQA: 12 Date: 07/11/16  
 QA: N/C Closed: 10 Date: 07.11.16

NCR: <u>32760</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.11.15	6.0	107B'S are B32791 on the bag: B33840 on the W/O  R.C. Human error	 05/11/12	correct B# on W/O		 07.11.15	 05/11/12	 07.11.15

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:43:15 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32760

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D35711

GUIDE



Comment: Qty.: 7.0000 Each(s)/Unit Total: 14.0000 Each(s)

GUIDE

batch:

B 32829 (4x) AS

31868 (1x) AS  
B 32829 (6x) AS

AS 07/11/15

14.0

D35713

GUIDE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

GUIDE

batch:

B 31869 (x2) AS

B 31869 (x2) AS

AS 07/11/15

15.0

D3572041

GUIDE ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

GUIDE ASSEMBLY

batch:

B 31870 (x2) AS

B 31870 (x2) AS

AS 07/11/15

16.0

D3578041

DOUBLER



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

DOUBLER

batch:

B 32831 (12x) AS

B 32831 (12x) AS

AS 07/11/15

17.0

D3610041

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

BRACKET

batch:

B 32832 (2x) AS

B 32832 (2x) AS

07/11/15

18.0

D36181

CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

CAP

batch:

B 32426 (2x) AS

B 32426

AS 07/11/15

19.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch:

M104603 (4x) AS

M104291 (4x)

AS 07/11/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32760

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

AN416A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch: M18949 (2x) AS

M18949

AS 07/11/15

21.0

AN425A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch: M104438 (4x) AS

M104438

AS 07/11/15

22.0

AN444A

Eyebolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Eyebolt

batch: M104806 (2x) AS M104810 (2x) AS M13791 \*

AS 07/11/15

23.0

MS24693S274

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

batch: M104214 (2x) AS

M104214

AS 07/11/15

24.0

MS24694S56

SCREW



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

SCREW

batch: M104407 (3x) AS

M14198

AS 07/11/15

25.0

MS24694S58

Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 20.0000 Each(s)

Screw

batch: M11735 (10x) AS

M104404

AS 07/11/15

26.0

MS24694S60

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch: M104407 (1x) AS

M104407 (1x)

AS 07/11/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-702-641<sup>B</sup> PAR #: N/A Fault Category: Prod / Pack NCR: Yes No DQA: 62 Date: 07/11/16  
 QA: N/C Closed: 7 Date: 07.11.16

NCR: <u>32760</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-15	220	AN4-44 bolts were placed in the bag. AN44-4A bolt required.  RC: New Employee, was not aware of part difference.	<u>[Signature]</u> 05/11/15	Add eye bolt : correct.	<u>[Signature]</u>	<u>[Signature]</u> 07-11-15	<u>[Signature]</u> 05/11/15	<u>[Signature]</u> 07-11-15

NOTE: Date & initial all entries



Date: Wednesday, 6/6/2007 1:43:15 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32760

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 52.0000 Each(s)

Washer

batch:

M105426(26x)KS

M102929

AS 07/11/15

28.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch:

M105408

(4x) AS

M103962(4x)

AS 07/11/15

29.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

batch:

M105054

(12x) AS

M103914 (12x)

AS 07/11/15

30.0

CR321244

Cherry Rivet



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Cherry Rivet

batch:

B102809

(24x) AS

M166012 (24x)

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-041B CHG001

Location:

PPP Rev:

Rev B

AS 07/11/15

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07/11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-11-15	31-0	QC 4 required for kyt inspection perm. change	E	07-11-15		<i>[Signature]</i> 07-11-15	<i>[Signature]</i> 07-11-15

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1*	1*			1*	D3569-3	DECAL
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL

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Revision: D

Date: 07.04.12

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: D

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